Work Order ID 58068 April 22, 2010 2:20:39 PM					Page 1
Item ID: D4048-6	Ассер	t		Setup Start	
Revision ID: Item Name: Mounting Lug		• • · · · ·		Stop	
Start Date: 4/22/10 Start Qty; 2.00 Required Date: 4/30/i0 Req'd Qty: 2.00		Cust Item ID: Customer:	·		£ .
Approvals: Process Plan: QC:	Date: 10-41-22 Too Date: SPO	ling: Date:	The second secon	Run Start	
Sequence ID/ Operation Work Center ID Description	s	et Up/ Draw I	Oraw Plan Acco		Reject Insp. Number Stamp
*Draw Nbr Revision Nbr D4048 A					
Dandsaw Jeaspa Bandsaw CUT BL	0. 0. ANK 5.330" LONG	00 L.D. 10/05/0	z Z		
			9	Ø	.
HAAS I Memo HAAS CNC vertical machine #1 MILL A: DWG,RI FOLIO F DEBUR	S PER DWG AND FOLIO FA897 EV: A REV: A	00 MW 10/05/05			- 10 - 10 - 10 - 10 - 10 - 10 - 10 - 10

W/O:			WC	ORK ORDER CHANG	iES			***		
DATE	STEP	PR	PROCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
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DATE STEP Descrip		Description of NC	n of NC Corrective Action		Section B Sign &			ation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		gn & Date	Section	on C	Chief Eng	QC Inspector
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		₹								

April 22, 2010 2:20:40 PM

Required Date: 4/30/10

Item ID:

D4048-6

Accept



Setup Start

Stop



Revision ID:

Item Name:

Mounting Lug

Start Date:

4/22/10

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID: Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date: ____

Start Run



Date: SPC(Y/N):

Date:_____

Stop



Sequence ID/ Work Center ID

120

QC

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours**

0.00

0.00

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

QC8- Inspect parts - second check

Memo

0.00

0.00

and 10/05/05

Quality Control

Chemical Conversion Coat per QSI005 4.1

Memo

0.00=7 m/ 10/05/05/Q

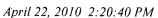
140

HandFinish

Hand Finishing

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE			C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Dispositio	n:	QA: N/C	Close	ed:		Date: _	
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		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 58068







Page 3

Item ID:

D4048-6

Accept



Setup Start

Stop



Revision ID:

Item Name:

Mounting Lug

Start Date: 4/22/10 Required Date: 4/30/10

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Mask 0.257" holes and indicated channel prior to powder coat

Tooling:

Date:

Run Start



QC: _____ Date:____

SPC (Y/N):

Set Up/

Run Hours

Number

Draw

Date:

Draw

Rev.

Plan

Code

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ **Work Center ID**

150



Powder Coating

Operation **Description**

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114207

POWDER COAT: Start Time: 9:15pm

Oven Temperature: 320°(= Finish Time: 9.450m

0.00

0.00

JU 10/05/06

Accept

Qty

br 10-5-6

Reject

Number

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

Packaging

Memo

Identify as per dwg & Stock Location: 76

0.00

0.00



170

Packaging

	-									,
W/O:			WO	RK ORDER CHANG	ES					M 616-4-4-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-
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	Res	solution:	Disposition	n:	_ QA: N/0	Clos	sed:		Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (N	CR)	,			
DATE STEP		Description of NC Corrective Action						ation	Approval	Approval
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April 22, 2010 2:20:41 PM

Item ID:

D4048-6

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 4/30/10

Mounting Lug

Start Date:

4/22/10

Start Otv: 2.00

Req'd Oty: 2.00



Cust Item ID: Customer:

Reference:

Δ	nn	ra	v a	le٠

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

180

Operation Description

OC21- Final Inspection - Work Order Release

Set Up/ Run Hours

Number

Draw

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number Stamp

Insp.

Quality Control

Memo

0.00

0.00

	•									1
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE STEP Descript		Description of NC		Corrective Action Section			Verific	cation	Approval	Approval
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									·	
					1					

Picklist Print

April 22, 2010 2:20:39 PM

Work Order ID: 58068

Parent Item: D4048-6

Component Item ID/

Parent Item Name: Mounting Lug

Comments:

Item Name

IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC Rev:B as per dwg revA DD 10.02.18 verified by:EC

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location

No

Last Location

IPP

Route Seq ID 100

Unit of Measure Hand

Oty on 17.0000

Qty To Pick 0.9356

Start Date: 4/22/10

Start Oty: 2.00

Remaining

Otv

Issued

Date Issued

Required Date: 4/30/10

Required Oty: 2.00

Status

Page 1

M6061T6B1.500X04.00

6061T6 Bar 1.500 x 4.00

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT09	17	
113797	17	

-9356 S& 10/05/0Z

100

9.14

Dart Aerospace Ltd

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W/O:			٧	ORK ORDER CHANG	ES		No. 11	
DATE	STEP	PRO	PROCEDURE CHANGE			Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	solution:	Disposit	ion:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Secti		Verification	on Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
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		•						

DART AEROSPACE LTD	Work Order:	<i>6</i> 806 <i>8</i>
Description: Mountlan Lug	Part Number:	D4048-6 °
Inspection Dwg: 4048 Rev: A		Page 1 of 1

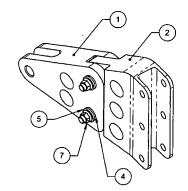
FIRST ARTICLE INSPECTION CHECKLIST

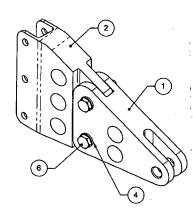
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.11	±.03	5.14	V 55.			
1.38	±.03	1.375	V			
1.00	± 03	1.00				
.970	±.010	770				
415	1,015 ,000	664	V/			
.293	2,010	1986.				
211.	±.010	.117				
3.75	±.03	3.745	<i>J</i>			
3.000	2.010	3.999				
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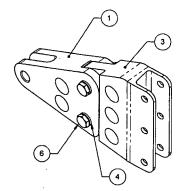
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10/01/05		7/03/03	<u></u>	

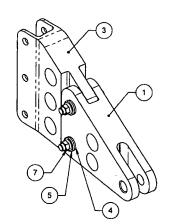
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	Rev	Date	Change	16 17 11 8 4	
Ĩ	Α		New Issue	KJ/JLM	











ITEM	QTY -041	QTY -042	P/N	Description
	Х		D4048-041	MOUNTING LUG ASSY
		х	D4048-042	MOUNTING LUG ASSY
_ 1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		. 1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

Α .	NEW IS	SUE		RF 10.01.29					
REV.			DESCRIPTION	BY	DATE				
DESIG	7	RF	DART AFROSP	DART AEROSPACE LTD					
DRAW	4	RF	HAWKESBURY, ONTARIO, CANADA						
CHECKED (1)			DRAWING NO.	,	REV. A				
MFG. A	PPR.	91	7 D4048		SHEET 1 OF 9				
APPRO	VED	10	TITLE	SCALE					
DE AP	PR.	-#-	MOUNTING LUG ASSY						
DATE 10.01.29			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED ON THE DIFFERS CONDITION THAT IT NOT TO SECURED YOR MAY PURPOSE ON COPYRIGH COMPANDANT TO THAT OFFICE PURPOSE WITHOUT AND THAT PURPOSE ON THE PRIVATE OF THE PURPOSE OF THE PURPOS						

D4048-042 MOUNTING LUG ASSY (SHOWN)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4048-041/-042: 1.16 lbs
8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

5

3

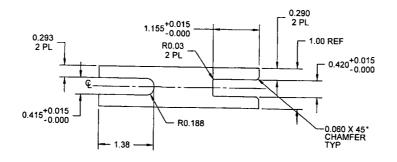
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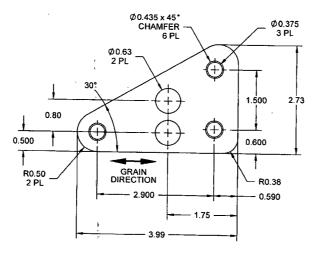
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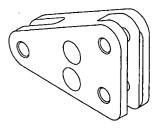


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D4048-1 MOUNTING LUG



С

В

Wlo 58068

DELEASED 2010 -02-7 1 6

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-220/8 (OR AMS 4160) REF DART SPEC. M6061T6B 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.315 HOLES PRIOR TO POWDER COAT 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A

6) IDENTIFICATION: N/A 7) WEIGHT: 0.47 lbs

DESIGN	RF	DART AEROSPACE	ITD				
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	a)	DRAWING NO.	REV A				
MFG. APPR.	91	D4048	SHEET 2 OF 9				
APPROVED	149	TITLE	SCALE				
DE APPR.	#	MOUNTING LUG ASSY	NTS				
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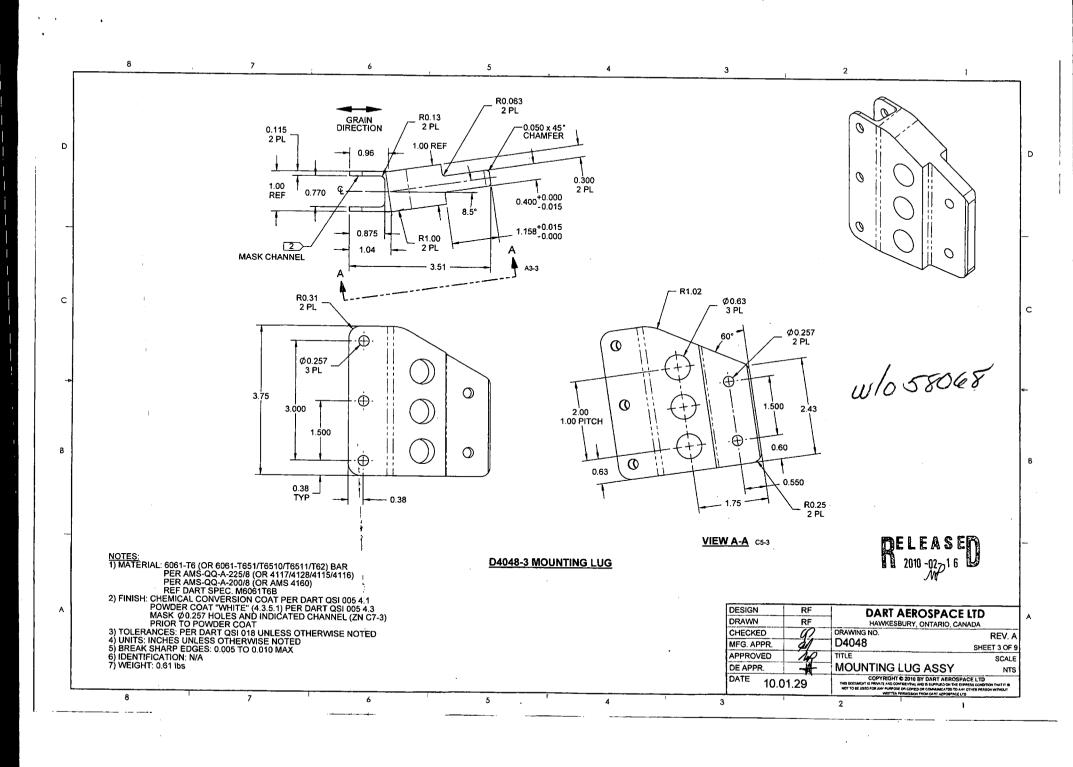
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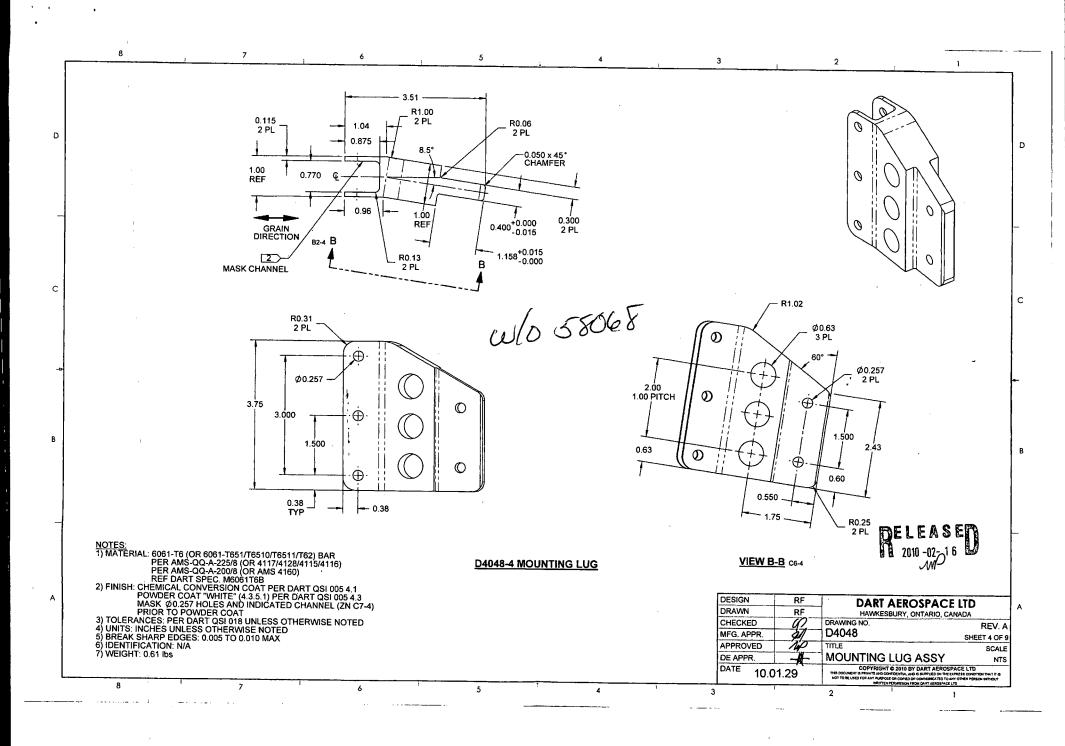
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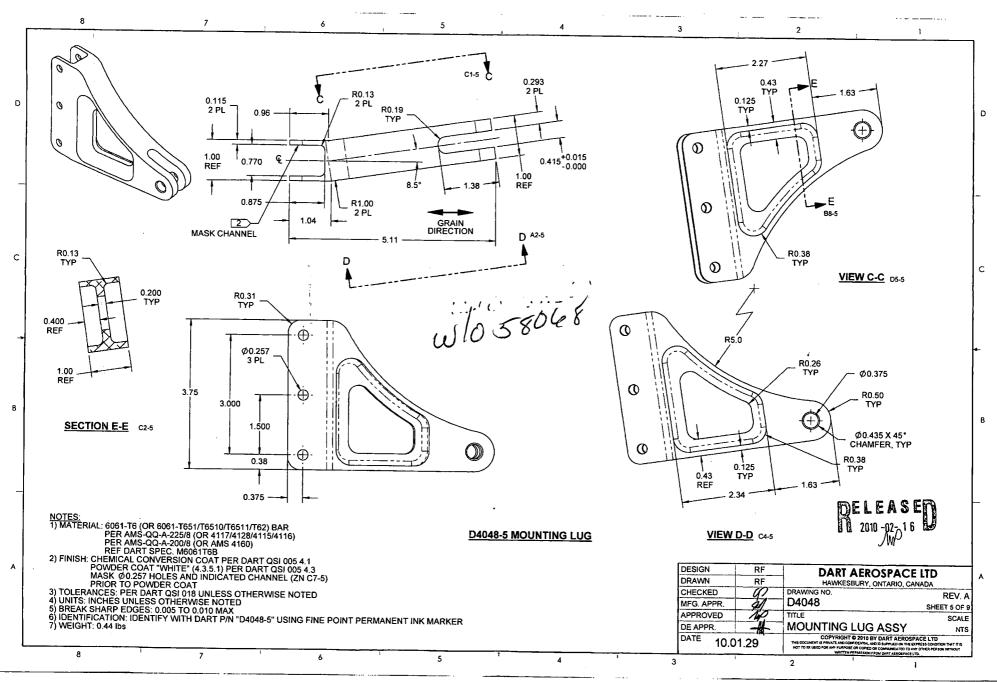
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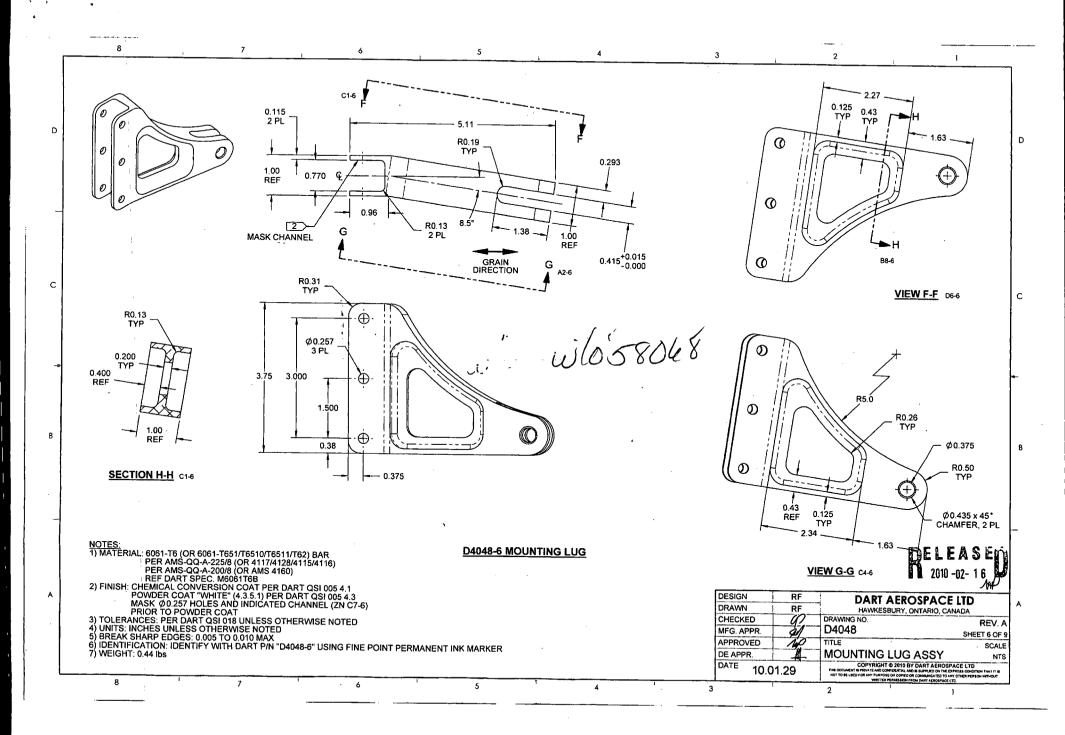
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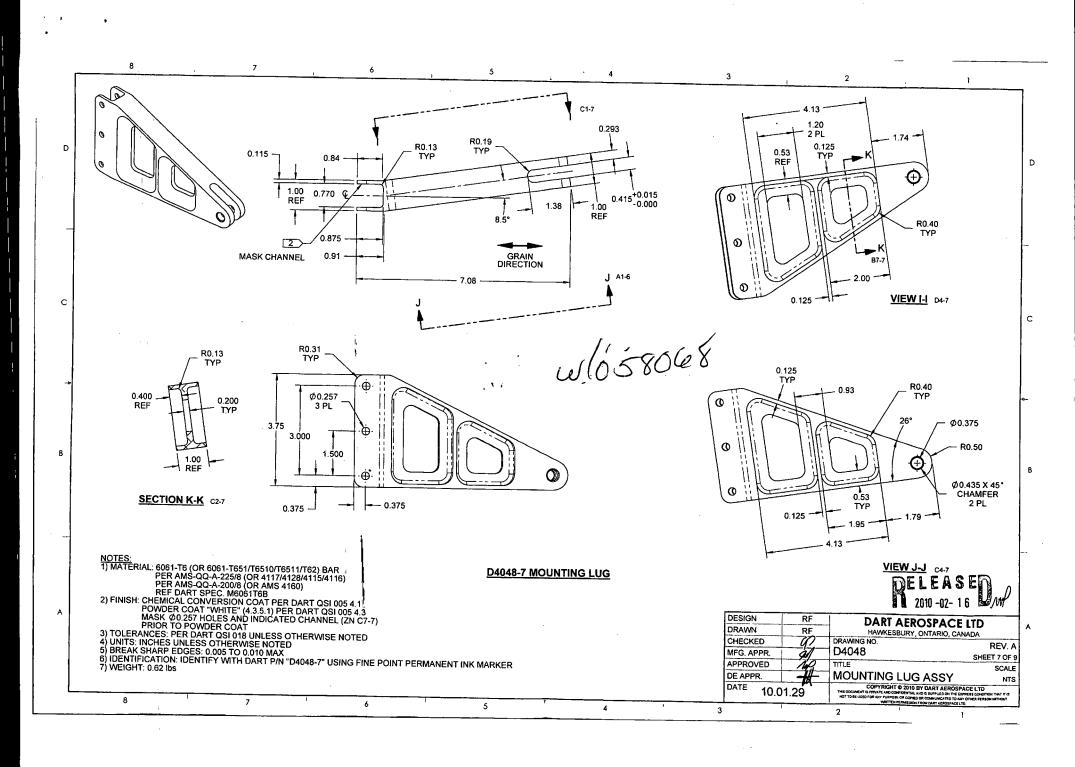


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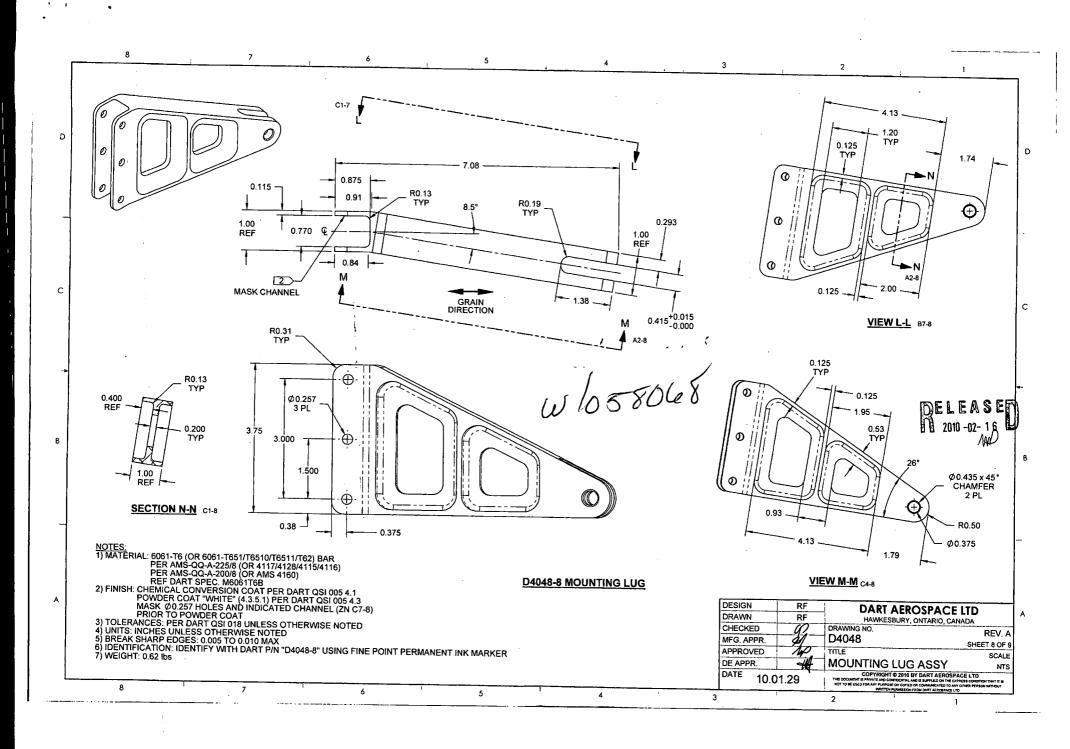


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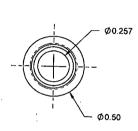
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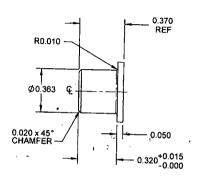


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W/0 58068

D4048-9 BUSHING

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN RF		DART AEROSPACE LT	
DRAWN RF		HAWKESBURY, ONTARIO, CANADA	ע
		DRAWING NO.	
MFG. APPR.	9/	∏D4048	REV. A HEET 9 OF 9
APPROVED	10	TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE L 143 DOCUMENT O PRIVATE AND COMPOSITION, AND 18 SUPPLIED ON THE COPYESS OF HOT TO BE USED FOR ANY PURPOSE OR COPYED OR COMMENCE TED TO JAN OTHER WRITTON PRIMASSON FROM DART AEROSPACE LTD.	TD

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
D.4.T.F	STEP	Description of NC		Corrective Action Section B	Verification	Annroyal	Approval			
DATE		STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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